

Date: Wednesday, 2/20/2008 4:21:02 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : R/H LOW PROFILE BASKET BASE ASS'Y
 Job Number : 37524
 Estimate Number : 13171
 P.O. Number :
 This Issue : 2/20/2008 S.O. No. :
 Prsht Rev. : NC
 First Issue : 1/1 Type : LARGE FAB ASSY
 Previous Run : 37523
 Part Number : D3712042
 Drawing Number : D3712 U/R
 Project Number : N/A
 Drawing Revision : U/R
 Material :
 Due Date : 3/10/2008 Qty: 1 Um: Each
 Written By :
 Checked & Approved By :
 Comment : Est Rev: A new issue 08-01-30 DD verified by: EC



Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M304TS0750W065 304 SQ Tube.75x.75x.065W



Comment: Qty.: 44.7920 f(s)/Unit Total : 44.7920 f(s)
 304 SQ Tube.75x.75x.065W

1- Cut Ribs as per dwg from 3/4" x 3/4" x 0.065 wall 304/316 SS tubing.

QTY	PART NUMBER	BATCH
2	D3726-1	M107038
2	D3727-1	M107038
2	D3734-1	M107038
6	D3735-1	M107038
3	D3739-1	M107038
3	D3740-1	M107038

21 D3759-1
 2- deburr

B37663

08/02/26

2.0 D23273 Spacer Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
 Spacer Bushing
 batch B36697

08/02/26

3.0 D2581 Mounting Bracket



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
 Mounting Bracket
 batch B36481 ✓

08-03-04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 2/20/2008 4:21:03 PM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: R/H LOW PROFILE BASKET BASE ASS'Y

Job Number: 37524

Part Number: D3712042

Job Number:



Seq. #:

Machine Or Operation:

Description :

4.0

D37251

HOOP



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
HOOP
batch B37127

Pl 08.02.27

5.0

D37481

HINGE HALF



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)
HINGE HALF
batch B37305V

Pl 08.03.04

6.0

D31661

Basket Hoop



Comment: Qty.: 5.0000 Each(s)/Unit Total : 5.0000 Each(s)
Basket Hoop
Batch: B37156

Pl 08.02.26

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

- 1- take D3166-1 and trim as per dwg D3746 to make D3746-1
- 2- take D3746-1 and drill holes as per dwg D3646
- 3- drill holes in both D3727-1 as per dwg D3727
- 4- take 1x D3735-1 and drill holes as per dwg D3735
- 5- deburr
- 6- assemble as per dwg D3712 and weld as per QSI004

Pl 08.03.10

8.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

DD 08.03.10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: R/H LOW PROFILE BASKET BASE ASS'Y

Job Number: 37524

Part Number: D3712042

Job Number:



Seq. #:

Machine Or Operation:

Description :

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

PD 08-03-10

10.0

M304EX07516F

Expanded Metal Flat Stai



Comment: Qty.: 39.9000 sf(s)/Unit Total : 39.9000 sf(s)

Expanded Metal Flat Stainless Steel

Pick:

Qty Part Number

Description

Batch

38sq.ft M304EX0.75-16F

Expanded Metal

M106798V

PL 08-03-04

11.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1- cut mesh to fit inside basket base and sides as per dwg D

2- weld mesh as per dwg D3712

PL 08-03-11

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

ASS 08-03-12 ENGINEERING APPROVAL

PL 08-03-12 (C)

13.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 08-03-12 (C)

14.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

M107005

FL 08/03/12 (C)

15.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-03-13

(C)

16.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

M108/03/14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: JP Date: 08/03/17
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: R/H LOW PROFILE BASKET BASE ASS'Y

Job Number: 37524

Part Number: D3712042

Job Number:



Seq. #:

Machine Or Operation:

Description :

17.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



POSITIVE RECALL

EFFECTIVE 08/02/21

RELEASED

AUTH

DATE

02.03.17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

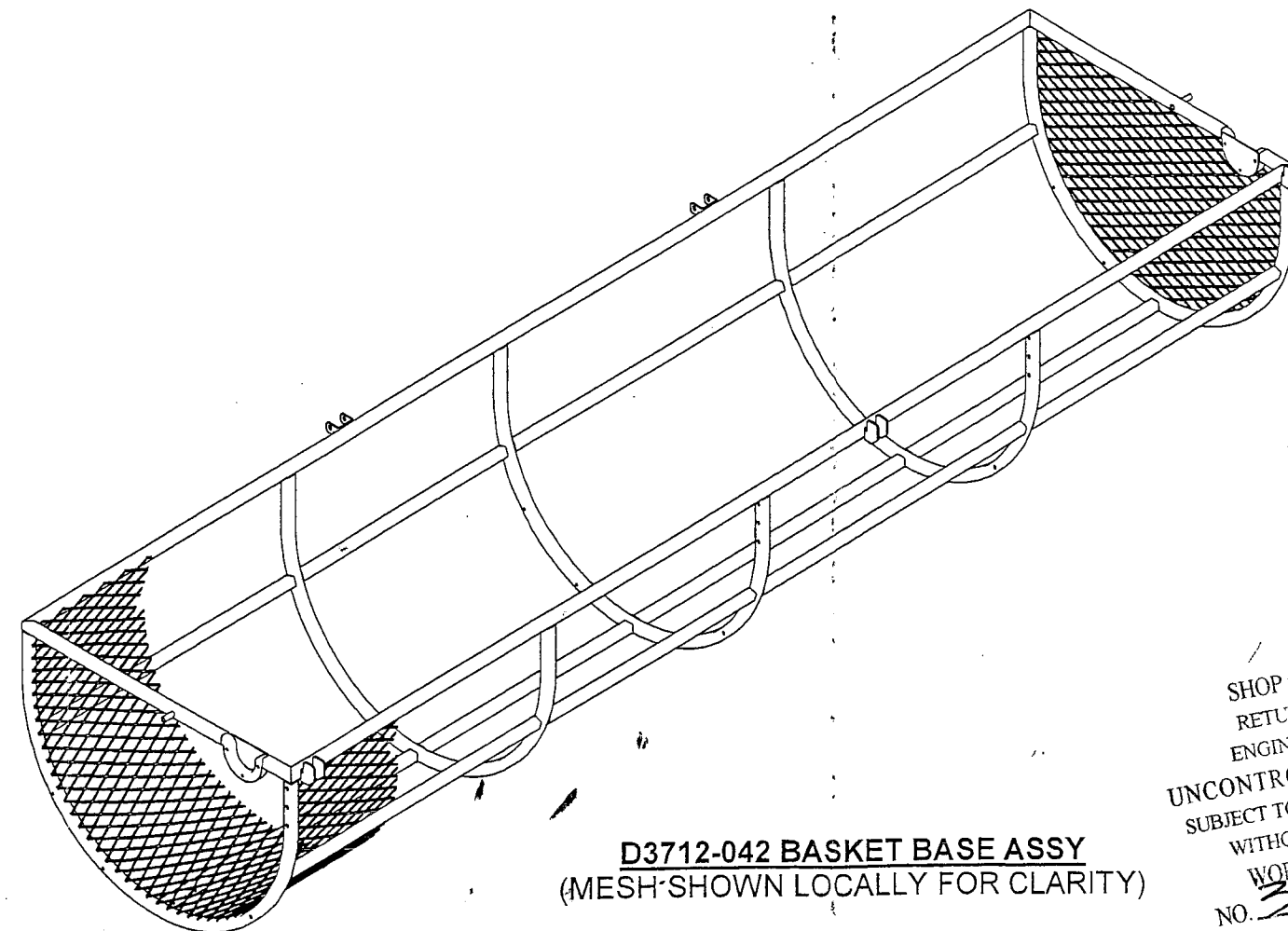
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

QTY. -041	PART NUMBER	DESCRIPTION
X	D3712-042	BASKET BASE ASSY
2	D2327-3	SPACER BUSHING
2	D2581	MOUNTING BRACKET
2	D3725-1	HOOP
2	D3726-1	RIB
2	D3727-1	RIB
2	D3734-1	RIB
5	D3735-1	RIB
1	D3735-3	RIB
3	D3739-1	RIB
3	D3740-1	RIB
1	D3744-1	MESH
1	D3745-1	MESH
1	D3745-3	MESH
1	D3746-1	RIB
1	D3746-3	RIB
2	D3746-5	RIB
1	D3746-7	RIB
3	D3748-1	HINGE HALF
2	D3757-1	BLANKING PLATE
6	AN3-10A	BOLT
12	AN960JD10	WASHER
6	MS21042L3	NUT



D3712-042 BASKET BASE ASSY
(MESH SHOWN LOCALLY FOR CLARITY)

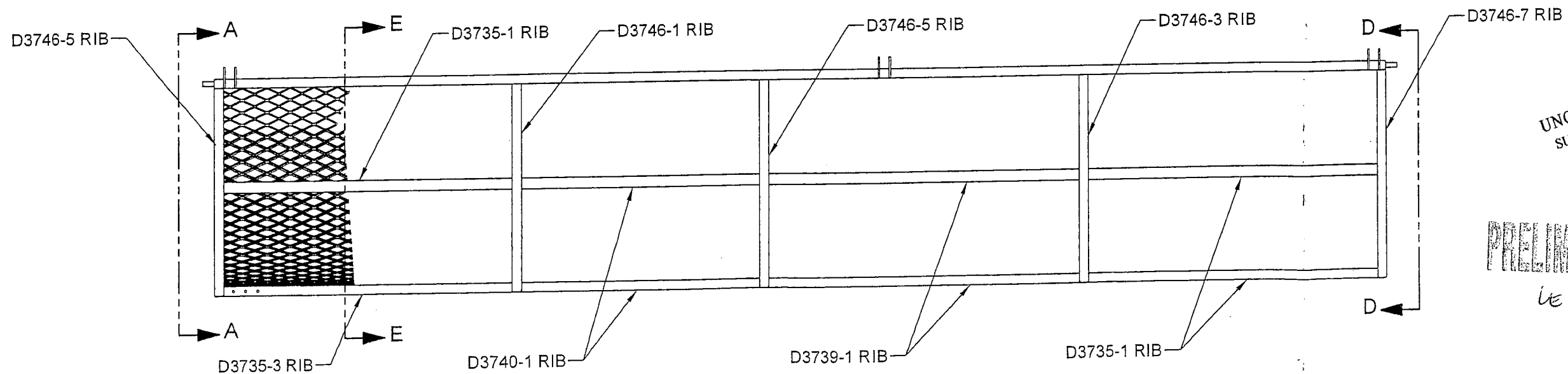
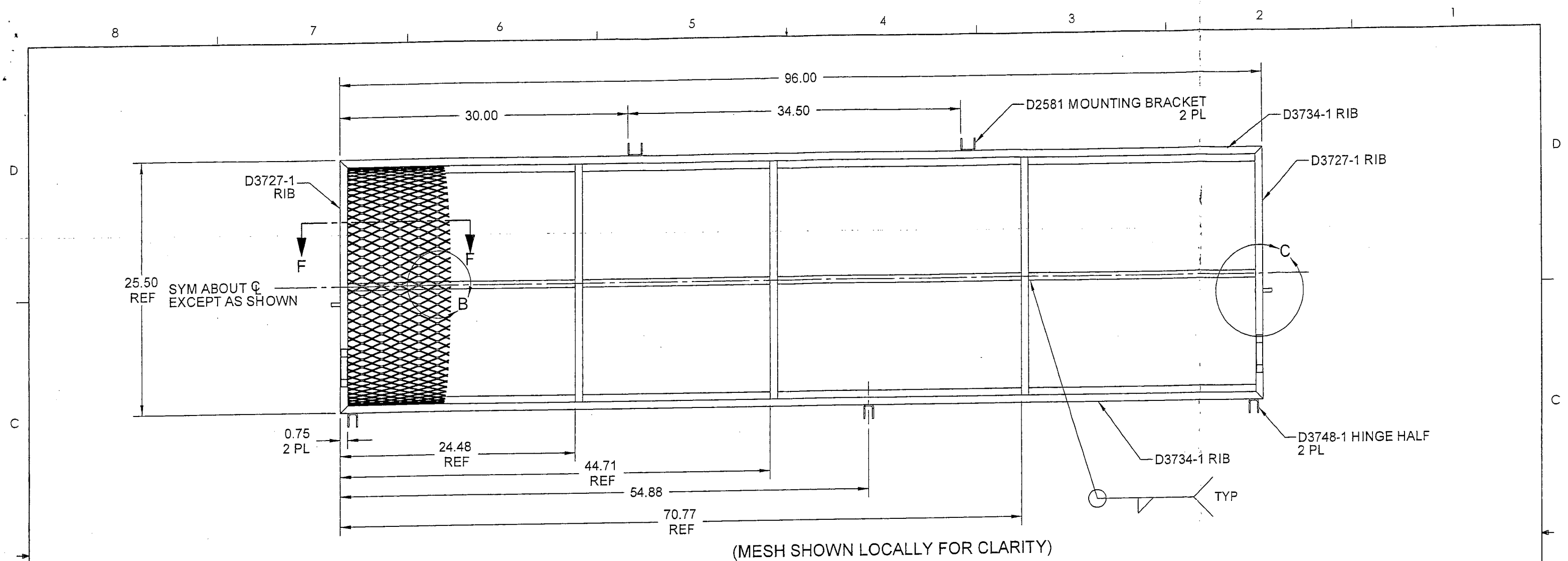
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WORK ORDER
NO. 37524

PRELIMINARY ISSUE

LE 08.02.15

- NOTES:
- 1) MATERIAL: NONE
 - 2) FINISH: POWDER COAT GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 41.53 lbs
 - 8) WELDING: PER DART QSI 004

A	NEW ISSUE	AJS	08.01.29
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	LE	DRAWING NO.	REV. A
MFG. APPR.		D3712	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.	LE	BASKET BASE ASSY	NTS
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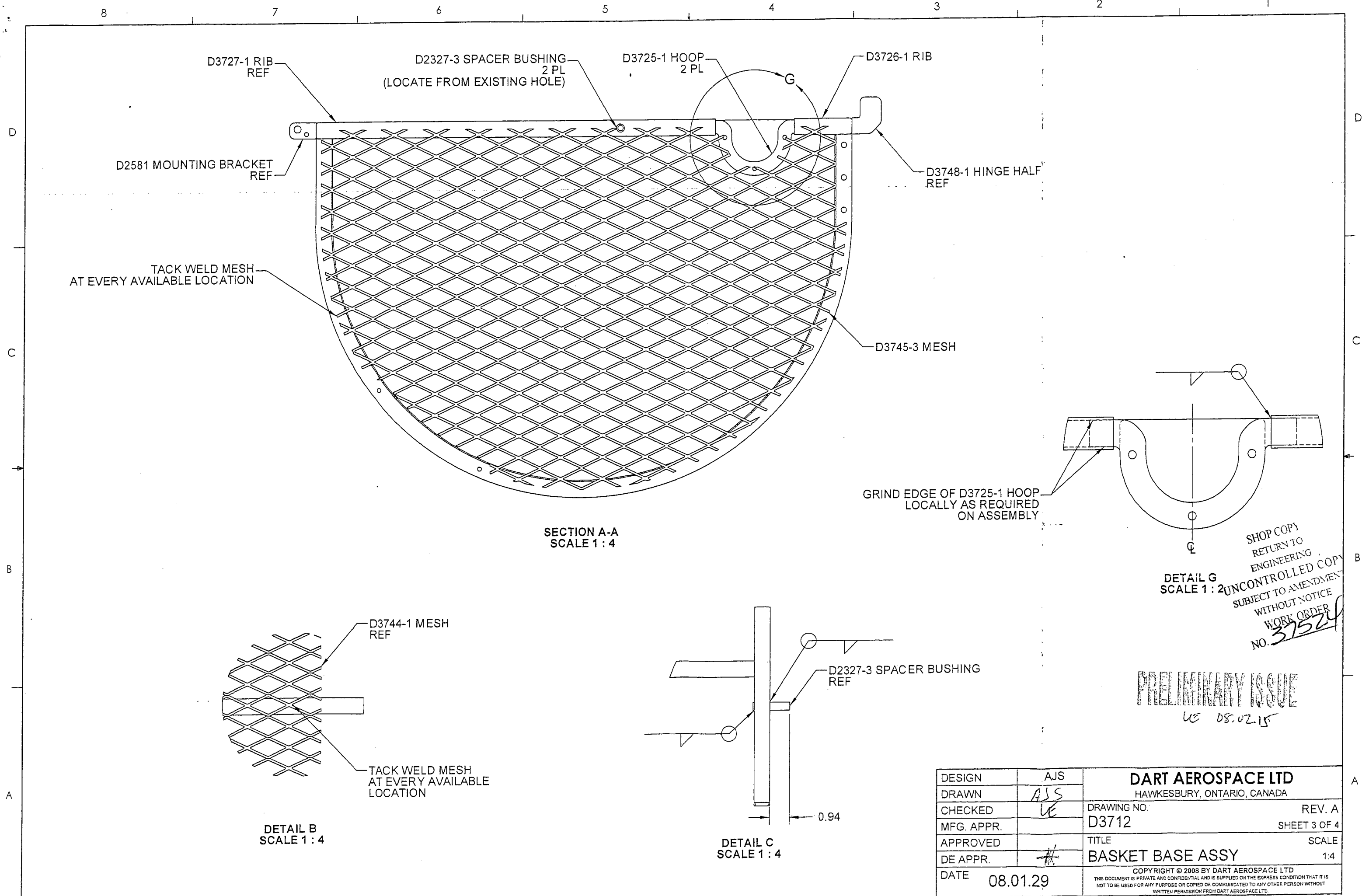


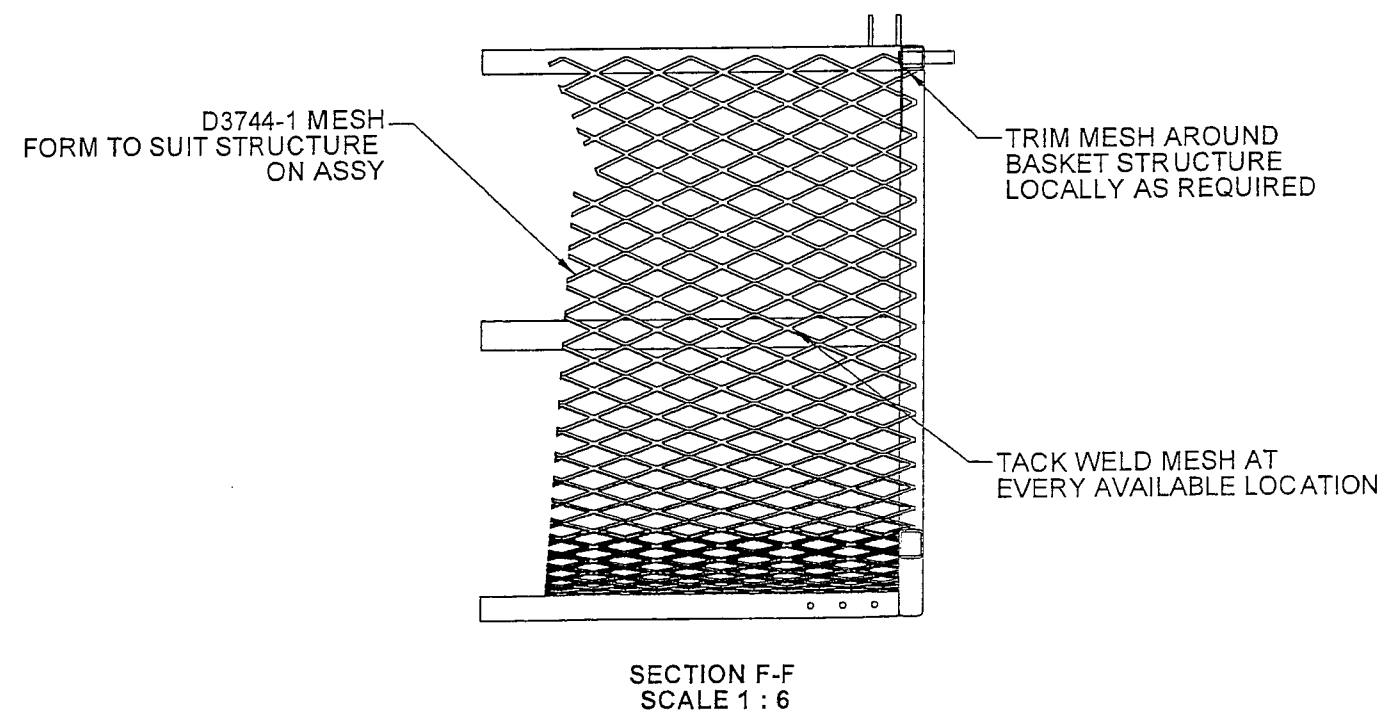
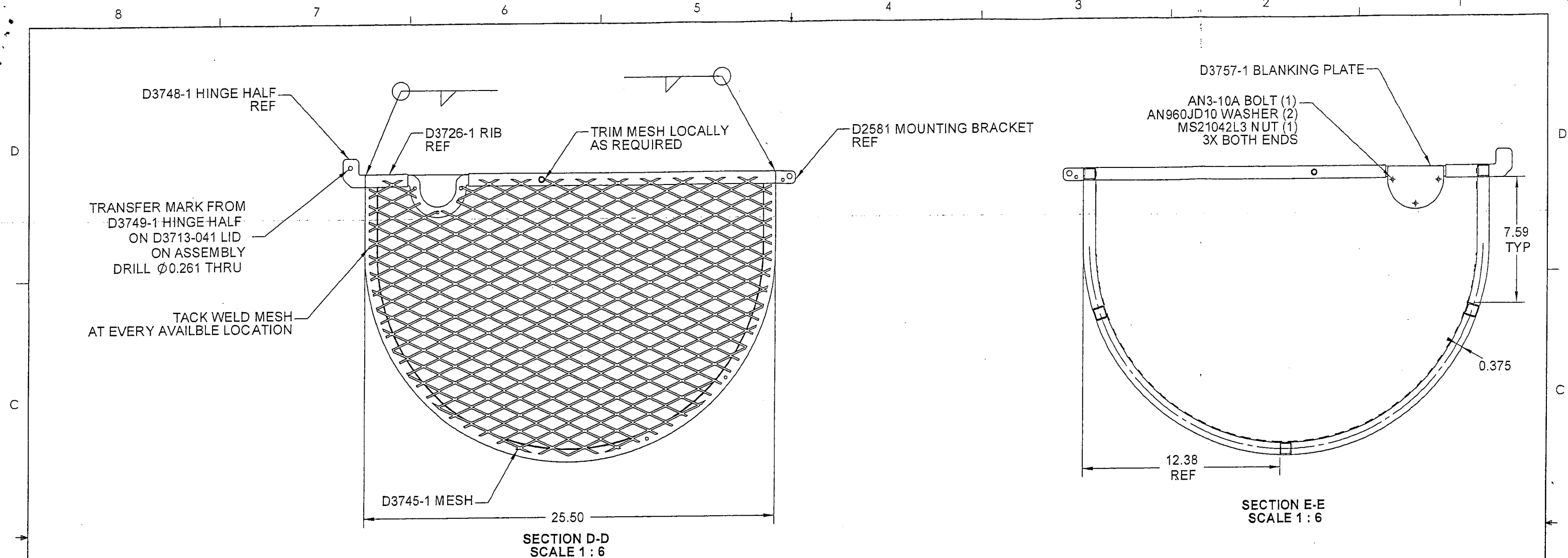
D3712-041 BASKET BASE ASSY

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PRELIMINARY ISSUE
08.02.15

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MFG. APPR.		D3712	SHEET 2 OF 4
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DE APPR.	HA	BASKET BASE ASSY	1:10
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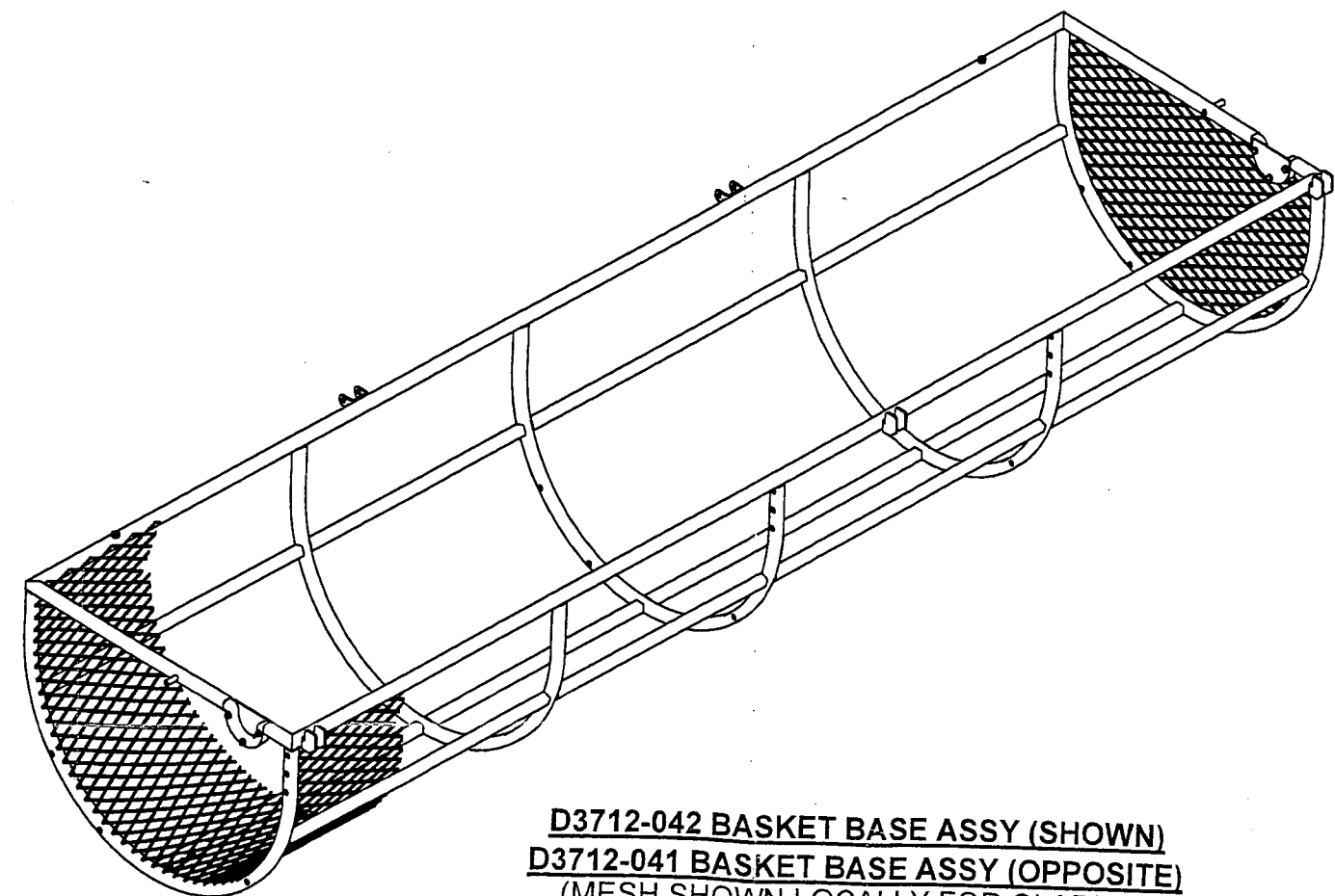


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08.02.15

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MFG. APPR.			SHEET 4 OF 4
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DE APPR.	UE	BASKET BASE ASSY	1:6
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QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D3712-041	BASKET BASE ASSEMBLY
	X	D3712-042	BASKET BASE ASSEMBLY
2	2	D2327-3	SPACER BUSHING
2	2	D2581	MOUNTING BRACKET
2	2	D2931	BUMPER
2	2	D3725-1	HOOP
2	2	D3726-1	RIB
2	2	D3727-1	RIB
2	2	D3734-1	RIB
5	5	D3735-1	RIB
1	1	D3735-3	RIB
3	3	D3739-1	RIB
3	3	D3740-1	RIB
1	1	D3744-1	MESH
1	1	D3746-1	RIB
1	1	D3746-3	RIB
2	2	D3746-5	RIB
1	1	D3746-7	RIB
3	3	D3748-1	HINGE HALF
2	2	D3757-1	BLANKING PLATE
21	21	D3759-1	BUSHING
6	6	AN3-11A	BOLT
2	2	AN960JD8	WASHER
12	12	AN960JD10	WASHER
2	2	MS20600AD4W3	RIVET
6	6	MS21042L3	NUT

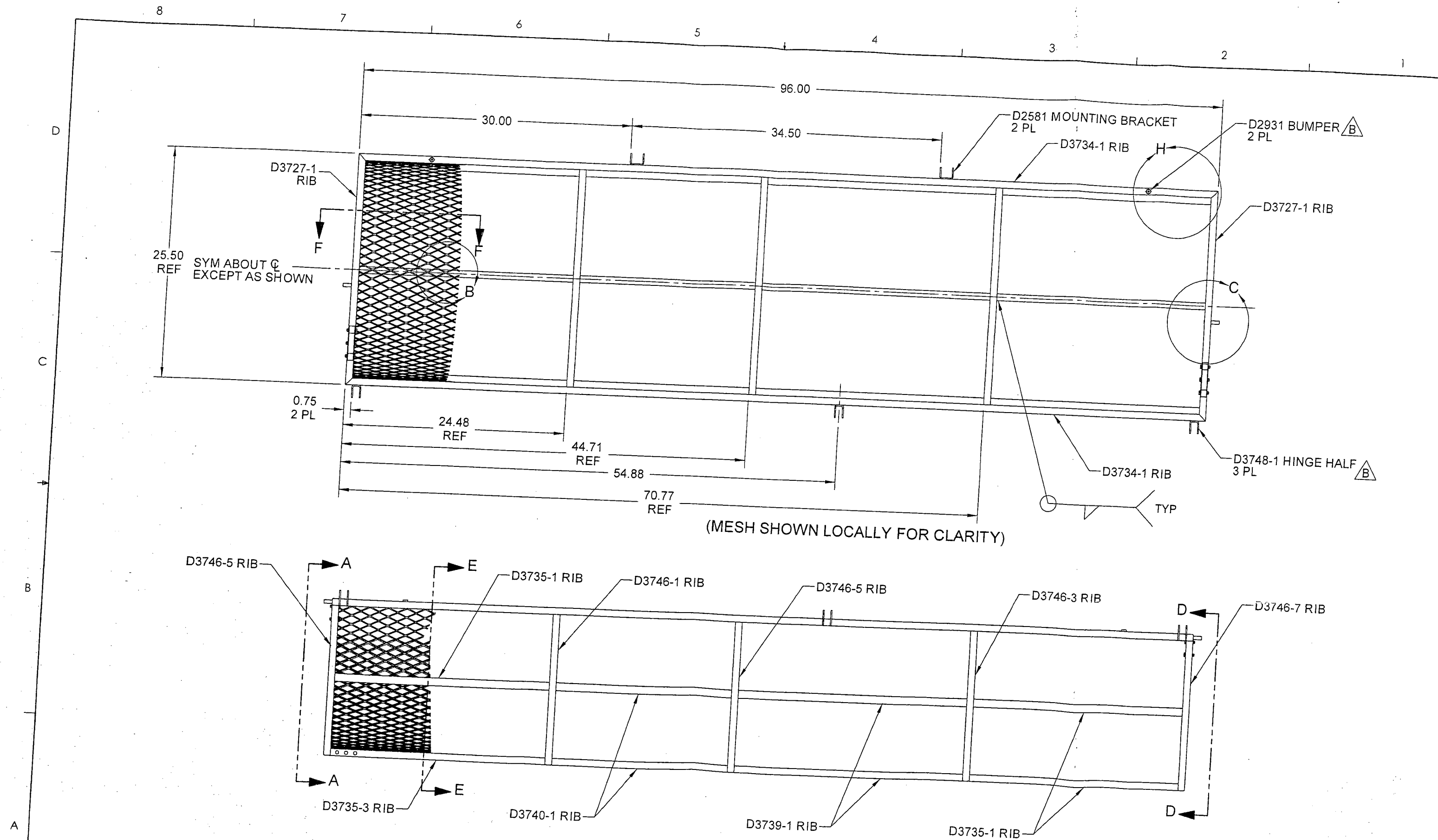


D3712-042 BASKET BASE ASSY (SHOWN)
D3712-041 BASKET BASE ASSY (OPPOSITE)
(MESH SHOWN LOCALLY FOR CLARITY)

NOTES:

- 1) MATERIAL: NONE
- 2) FINISH: POWDER COAT GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) WELDING: PER DART QSI 004
- 9) MASK ALL HOLES PRIOR TO POWDER COATING.

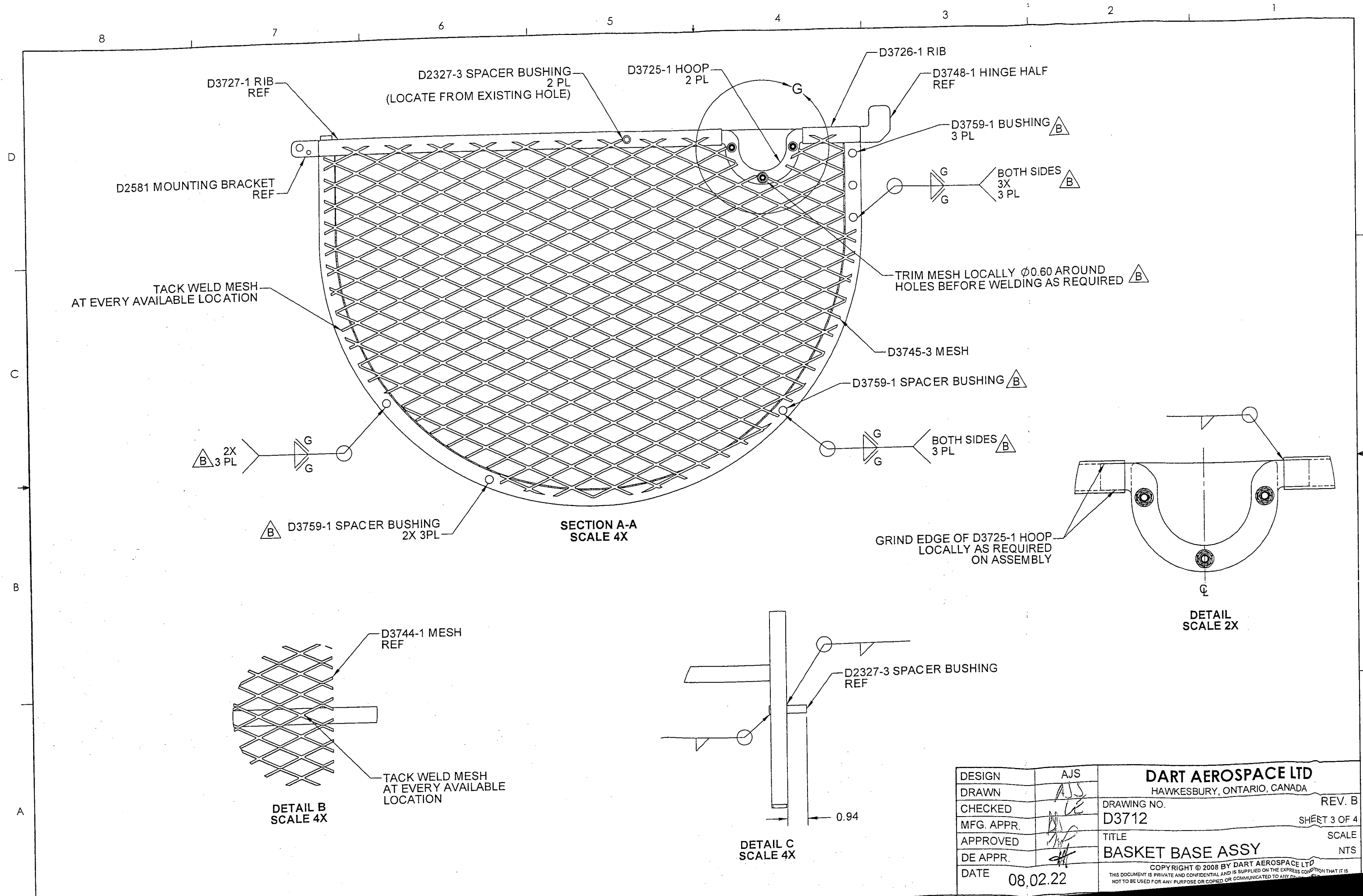
B	ADDED-041 ASSEMBLY. WEIGHT WAS 41.50 lbs. ADDED D2931 BUMPER & HARDWARE & D3759-1 BUSHINGS. SHEET 2 ZONE C2 QTY FOR D3748-1 WAS 2. SHEET 4 ADDED DETAIL H. SHEET 3 ZONE C3 & SHEET 4 ZONE C4. ADDED MESH TRIMMING INSTRUCTIONS. SHEET 4 ZONE D2 AN3-11A BOLT WAS AN3-10A P/L UPDATED ACCORDINGLY.	AJS	08.02.22
A	NEW ISSUE	AJS	08.01.29
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
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CHECKED	CE	DRAWING NO.	REV. B
MFG. APPR.	DS	D3712	SHEET 1 OF 4
APPROVED	JP	TITLE	SCALE
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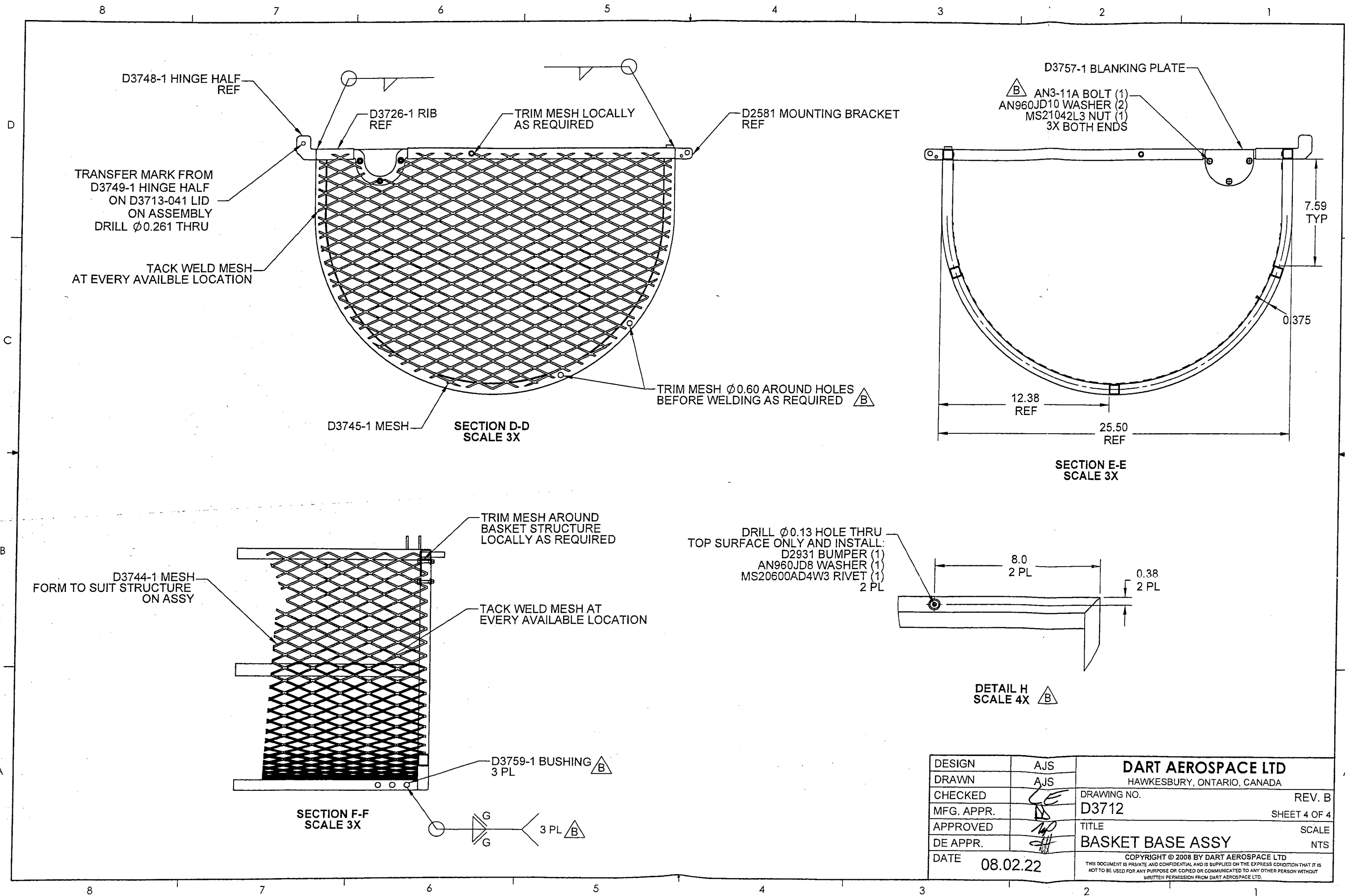
9 D3712-041 BASKET BASE ASSY (OPP)

9 D3712-042 BASKET BASE ASSY (SHOWN)

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. B
DRAWN	AJS		
CHECKED	KE	DRAWING NO.	D3712
MFG. APPR.	MP	TITLE	
APPROVED	MP		SHEET 2 OF 4



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CHECKED	LE	DRAWING NO.	REV. B
MFG. APPR.	AF	D3712	SHEET 3 OF 4
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